Blue

Work Order ID 53352

November 2, 2009 10:42:30 AM

Item ID: D3413-1 **Accept**

Revision ID: A

Item Name: Ring

Setup Start / Stop

Start Date: 02/11/2009 **Start Qty:** 20.00

Required Date: 13/11/2009 **Req'd Qty:** 20.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ____ **Date:** 09-11-2 **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Run Start / Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3413	Rev A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 Waterjet FLOW CNC Waterjet	FLOW WATER JET **Memo** 1-Cut as per Dwg D3413 Dwg Rev: A Prog Rev: A 2-Deburr if necessary	0.00 0.00 Deburr ~~= 7 mik oattlos~~	(5X)	HB / HB	9-11-2 / 9-11-4	(S)
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00		HB / HB	9-11-2 / 9-11-4	
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00 => Solulos	(HB)	f21		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3413-1 PAR #: ______ Fault Category: Small fab/WJ NCR: (Yes) No DQA: [signature] Date: 09-11-18

Resolution: Scrap Disposition: Scrap. QA: N/C Closed: [signature] Date: 09-11-18

NCR: 53352		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.11.02	100	Ø0.266 HOLE IS ENLARGED AND OVALIZED. of 26. R.C. Process/Jet offset	[initials] 09.11.02 per QS1 042	PARTS WITH HOLE LESS THAN OR EQUAL TO Ø0.276 ARE OK. HOLE DOES NOT BEAR FLIGHT LOADS. Qty +21 Parts to be scrapped	[initials] 9-11-4	[signature] 09/11/05	[initials] 09.11.02 per QS1 042	[signature] 09/11/05
		tolerance stack up: cut taper	[signature] QS1042	Hole size for 0.266Ø revised/reduced to accomodate the Jet offset.	[signature] 09/11/18	[signature] 09-11-18	[signature] QS1042	[signature] 09-11-18

NOTE: Date & initial all entries

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QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab Small Fab	Small Fab **Memo** 1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1 . =7 M-L 09/11/05	0.00 0.00				5X			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	=) S 02/11/05			X5	ϕ		
145 SprayPaint Spray Painting	Spray Painting per QSI005 4.2 **Memo** Prime B 110918 Spray Painat Delfleet Blue B 110077 Clear Delfleet B 113053	0.00 0.00				ml	09	11	09 (5)

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Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155 QC Quality Control	QC14- Inspect Spray Paint	0.00				ZT	09 -	11 - 10	
	Memo	0.00							
170 Packaging Packaging	Identify as per dwg & Stock Location: 120	0.00				9/11/11		SR	SA
	Memo	0.00							
180 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00					09	/11	/12
	Memo	0.00							

MF 09-11-11

Picklist Print

November 2, 2009 10:42:36 AM

Work Order ID: 53352

Parent Item: D3413-1RevA

Parent Item Name: Ring

Comments:

Start Date: 02/11/2009 **Required Date:** 13/11/2009

Start Qty: 20.00 **Required Qty:** 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.250X4.000 304 BAR .250 x 4.00		Purchased	No			100	f	9.1637	5.2632	1.5	9-11-? / 9-11-4	

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
MAT	9.1637		
105358	7.3637		105358
105643	1.8		
111821			111871

DART AEROSPACE LTD	Work Order:	53332
Description: Ring	Part Number:	D3413-1
Inspection Dwg: D3413 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [X] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.88	+/-0.030	3.879	✓			
Ø2.00	+0.012/-0.001	2.005	✓			
0.75	+/-0.030	.742	✓			
Ø0.266	+0.006/-0.001	.272	✓			
0.250	+/-0.010	.243	✓			

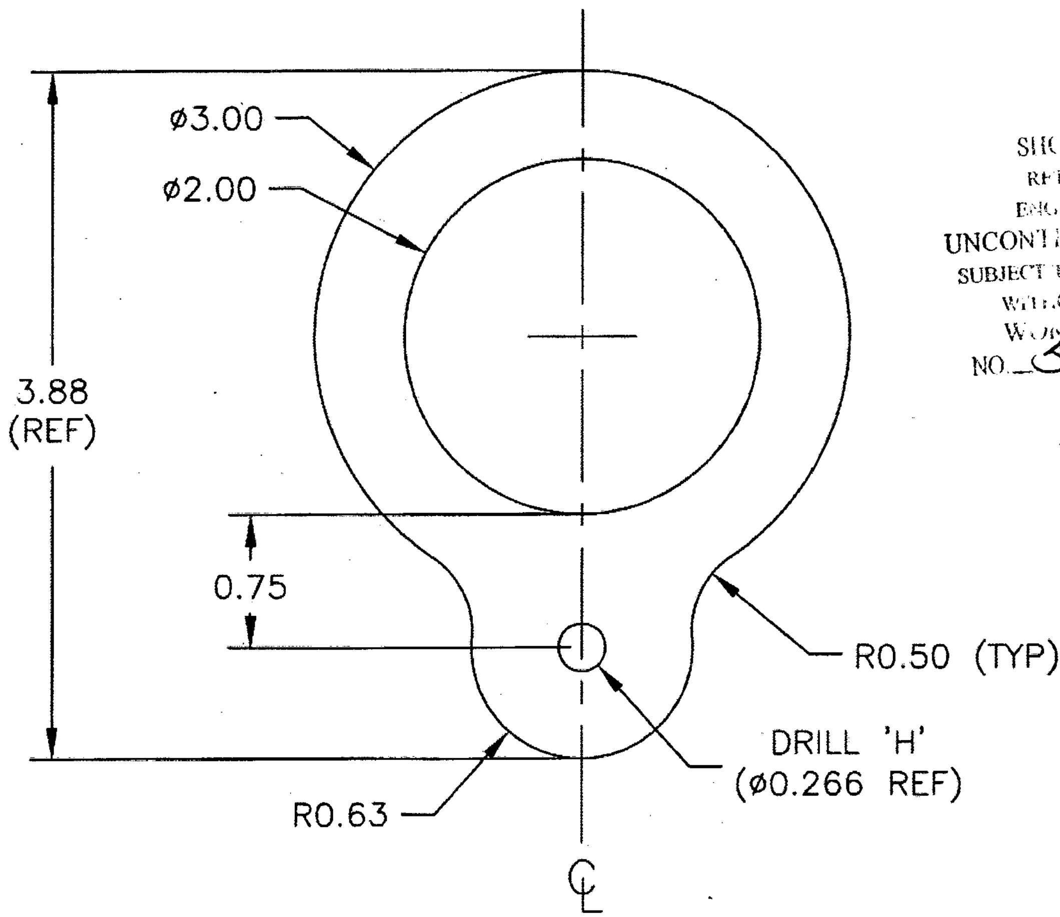
Measured by:	LB	Audited by:	[signature]	Prototype Approval:	N/A
Date:	9-11-2 9-11-4	Date:	09/11/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM [signature]	[signature]

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CP	CP		
CHECKED	APPROVED	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED 05-09-06

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO CHANGE WITHOUT NOTICE WORK ORDER NO. 53352 09-11-2



<u>D3413-1 RING</u>

1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES